

Work Order ID 84399

84399

Page 1

May-11-12 8:23:21 AM

Item ID: D4277-7

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib

Start Date: 11/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 25/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 12/05/11

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4277

D

100

0.00

100

Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D4277
2- Remove marking,debur

8 SAD 12-07-05

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

8 SY 12-07-16

120

Identify as per dwg & Stock Location: _____

0.00

120

Packaging

Memo

0.00

Packaging

STOCK IN BASKET CELL

SY 12-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Stop ***NS2***

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Start Date: 11/05/2012 Start Qty: 4.00

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Cust Item ID:

Required Date: 25/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/7/17
MCS 12/07/16

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NOTE: Date & initial all entries

Picklist Print

May-11-12 8:23:25 AM

Page 1
T

Work Order ID: 84399

84399

Parent Item: D4277-7

D4277-7

Parent Item Name: Rib

Start Date: 11/05/2012

Required Date: 25/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A 10.11.12 new issue DD verf:EC
11.01.20 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TS0.500W.049

Purchased

No

100

f

577.6882

0.1442

~~0.607158~~

1.2144

M304TS0 500W 049

**

SAO

12-07-04

Square Tubing

Location

Loc Qty

Loc Code

MAT034

577.6882093

118460

0.00001534

121328

109.018194

121565

468.67

1.2144

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

D4277-1 RIB

D4277-3 RIB

D4277-5 RIB

C

C

D4277-7 RIB

D4277-9 RIB

D4277-11 RIB

RELEASED
2011-02-24
M

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 84399 MCT
12/05/11

D4277-19 RIB



REV.	DESCRIPTION	BY	DATE
D	CHANGED ANGLE FROM 71° TO 61° (B3-3)	SC	11.02.09
C	D4277-19 RIB ADDED, ADDITIONAL HOLES ADDED IN D4277-1	SC	10.12.23
B	RMV -13/-15/-17 (OBSOLETE); -3: 6.09 WAS 20.25 (C5-2); -8: 13.50 WAS 2.00 (B4-2); -5: 24.25 WAS 26.25 (B5-2)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4277	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIBS	NTS
DATE	11.02.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

A

A

8 7 6 5 4 3 2 1

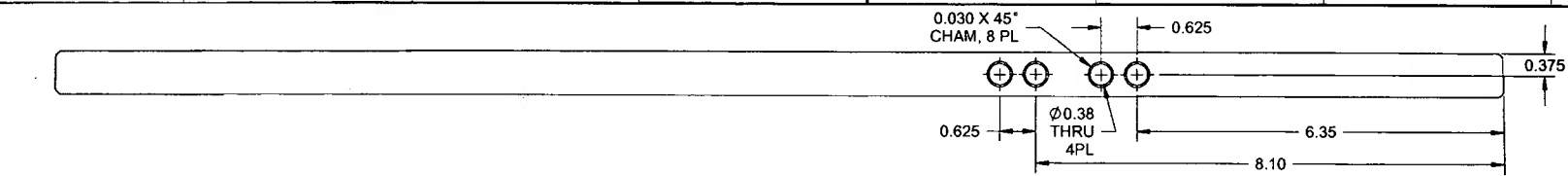
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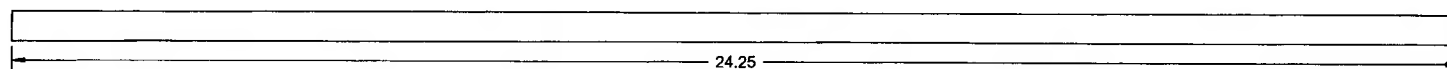
NOTE: Date & initial all entries



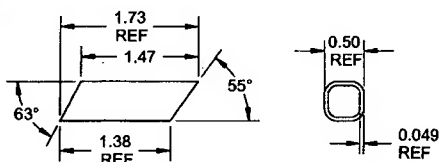
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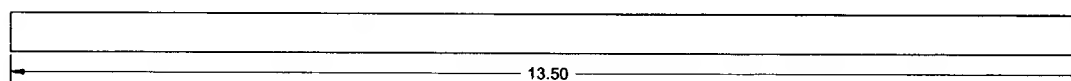
D4277-3 RIB



D4277-5 RIB



D4277-7 RIB



D4277-9 RIB

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL
-1: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
-3, -5, -7, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS.

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DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SK	DRAWING NO.	REV. D
MFG. APPR.	SK	D4277	SHEET 2 OF 3
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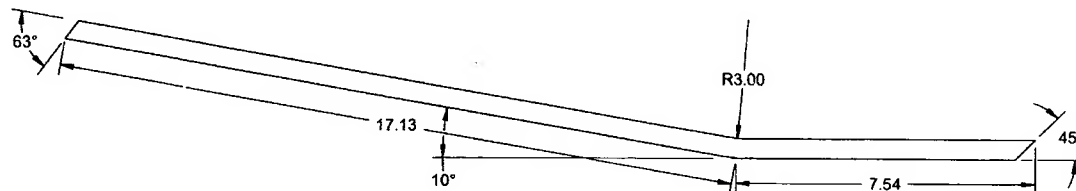
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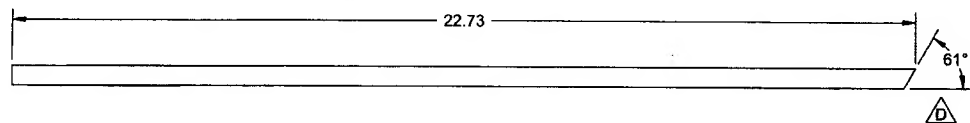
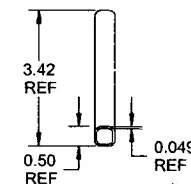
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NOTE: Date & initial all entries



D4277-11 RIB



D4277-19 RIB

RELEASED
2011-02-24

- NOTES:**
- 1) MATERIAL -11, -19: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
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